



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5953

Job Sheet 179524



Part No: D5953

Job Qty: 6 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/24/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG-REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:f ecn 826 06.12.06 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/24/18	7/24/18	0.00	0.00	Start Up Machining-4		SB 18/07/13
100	CNC Vertical Machining	6 pcs	7/24/18	7/24/18	0.79	15.79	HAAS1-1		11/18 18/07/16
110	QC	6 pcs	7/24/18	7/24/18	0.00	0.00	QC1		11/18 18/07/16
120	QC	6 pcs	7/24/18	7/24/18	0.00	0.00	QC8 Machining-4		11/18 18/07/16
130	HandFinish	6 pcs	7/24/18	7/24/18	0.00	0.55	HandFinish1		11/18 18/07/16
140	Powdercoat	6 pcs	7/24/18	7/24/18	0.00	0.28	Powdercoat1		11/18 18/07/16
150	QC	6 pcs	7/24/18	7/24/18	0.00	0.00	QC3		11/18 18/07/16
160	Packaging	6 pcs	7/24/18	7/24/18	0.00	0.00	Packaging3-2		11/18 18/07/16
170	QC21-SA	6 Ea	7/24/18	7/24/18	0.00	0.00	QC21		11/18 18/07/16

Part Op 100 - 1-Machine as per folio D5953, Ensure Batch Number is entered

Descriptions: 110 - Inspect on CMM as per folio CMM0017

140 - START TIME: 11:20 01.1320° FINISH 12:10

11/38839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	6 Ea (1 ea)	90-Start up Operation	5064074 L>5091798

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	6	45	0

Part Specifications

Specifications could not be found.

Plex 6/20/18 8:07 AM dart.lacelle.linda

PART AEROSPACE LTD		Work Order:	179524
Description: Inner Fwd Saddle		Part Number:	D5953
Inspection Dwg: D5953		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.745	1.745	1.745	1.745		
C	5.245	5.255		5.247	5.247	5.247	5.247		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.248	5.248	5.248	5.248		
F	4.745	4.755		4.747	4.747	4.747	4.747		
G	0.315	0.322		0.316	0.316	0.316	0.316		
H	1.522	1.532		1.528	1.528	1.528	1.528		
I	3.048	3.058		3.054	3.054	3.054	3.054		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.316	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.500	0.500	0.500	0.500		
N	1.615	1.635		1.625	1.625	1.625	1.625		
O	7.990	8.010		8.000	8.006	8.001	8.003		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.313	0.313	0.313	0.312		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.505	0.506	0.5035	0.494		
T	1.375	1.395		1.375	1.375	1.375	1.375		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:		Audited by:	mmk
Date:		Date:	18/07/20

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

DART AEROSPACE LTD		Work Order:	179524
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Inspection Dwg: D5953		Rev: B	Page 1 of 1

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				Recorded Actual Dimensions				By	Date
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C	5.245	5.255		5.247	5.247				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.248	5.248				
F	4.745	4.755		4.747	4.747				
G	0.315	0.322		0.316	0.316				
H	1.522	1.532		1.528	1.528				
I	3.048	3.058		3.054	3.054				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		0.316	0.316				
L	0.495	0.505		0.500	0.500				
M	0.490	0.510		0.500	0.500				
N	1.615	1.635		1.625	1.625				
O	7.990	8.010		8.002	8.003				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		0.312	0.313				
R	0.760	0.765		0.760	0.760				
S	0.490	0.510		0.494	0.494				
T	1.375	1.395		1.375	1.375				
U	2.000	2.020		2.000	2.000				
V									
W									
X									
Y									
Z									
AA									
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DQA: UAS Date: 18/7/16

QA Closed: 53 Date: AUG 15 2018

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: <u>179524</u>		DISPOSITION				AGAINST DEPARTMENT/PROCESS				Work Order update only	
Part No. <u>D5953</u>		Rework ☒ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐				Cross tube ☐ Small Fab ☒ Finishing ☐ Composite ☐				Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	
NCR No. <u>18-6938</u>		Step #: <u>1</u>				QTY Effective: <u>1</u>				MRB (QSI042) Approval <u>PD 18-07-16</u>	
Date: <u>18-07-16</u>		Description Work Order Deviation				Disposition				Completed By <u>UAS</u> <u>18-07-16</u>	
Entered the wrong offset resulting in the part being under tolerances.										Lead hand / Supervisor Approval Verification <u>27/</u> <u>18/07/23</u>	
										QC / QA Coordinator Approval <u>PD 18-07-16</u>	
Root Cause										FAULT CATEGORY	
Environment ☐		No Re-verification ☒		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Operator ☒		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☒	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☒		Drawing ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐	
Past Expiry Date ☐		Manufacturing Process ☐									
Misidentified ☐		Past Due ☐									
OTHER: ☐											